

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027143**Date Inspected:** 02-Feb-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA

CWI Name:	Chris Concha		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

SAS Travelers Supplementary Access Platforms

This QA Inspector made random shop observations and was informed by (WMI) production fitter Mr. Larry Swanson (WID #3058) that welding on the SAS Travelers Supplementary Access Platforms is still on hold pending RFI request to change the fit at hinge location.

E2/E3 Parking Tether Anchor Clamp

This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID #3035) performing Flux Core Arc Welding (FCAW) activities on the E2/E3 Parking Tether Anchor Clamp Assemblies. This QA Inspector observed Mr. Lopez tack welding and welding in the 2F horizontal positions on the E2/E3 Parking Tether Anchor Clamp Assemblies, randomly throughout the morning shift. Later in the afternoon shift this QA observed WMI production welder Mr. Eutimo Lopez (WID #3035) performing Shielded Metal Arc Welding (SMAW) activities on the E2/E3 Parking Tether Anchor Clamp Assemblies. QA Inspected noted that WMI has submitted an addendum to their Welding Quality Control Plan (WQCP) section J welder qualification to American Bridge/Fluor Enterprises for approval. Mr. Lopez has been verbally approved by METS representative Mr. Robert Mertz to perform SMAW welding. WMI is in the process of submitting a (SMAW) fillet weld procedure to American Bridge/Fluor Enterprises for approval. QA Inspector informed WMI Mr. Curt Bell that WMI in proceeds at their own risk pending approval of the Shielded Metal Arc Welding (SMAW) fillet welding procedure. Mr. Bell stated

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

that WMI is aware they are proceeding at their own risk. QA Inspector informed SMR Mr. Nicolai Hvass of the above information.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Chris Concha was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Concha verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

This QA noted above items observed appear to comply with contract documents.



Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910 , who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
